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D3196-4
Job Sheet 176837



Part No: D3196-4

Job Qty: 6 ea

Part Name: Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 5/24/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-08 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Machining-2		meml 18/6/29
100	Bandsaw	6 pcs	5/24/18	5/24/18	0.00	0.04	Bandsaw1		"
110	CNC Vertical Machining	6 pcs	5/24/18	5/24/18	0.96	5.98	HAAS1-3		"
120	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC2 Machining-2		"
130	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC8 Machining-2		9/24/18/05/21
140	HandFinish	6 pcs	5/24/18	5/24/18	0.00	0.50	HandFinish1		SAP 18-05-31
150	Powdercoat	6 pcs	5/24/18	5/24/18	0.00	0.36	Powdercoat3		18-6-5
160	QC	6 pcs	5/24/18	5/24/18	0.00	0.00	QC3		JUN 05 2018
170	Packaging	6 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		8-89
180	QC21-SA	6 Ea	5/24/18	5/24/18	0.00	0.00	QC21		JUN 06 2018

Part Op 180 - ***INSPECT MATERIAL FOR DEFECTS BEFORE CUTTING*** Cut blank: (0.75" x 1.50") x 34.750" long Bar
Descriptions: 110 - 1-Machine D3196-4 as per Folio FA339 and Dwg D3196Identify as D3196-4

150 - START TIME: 11:00 CUT: 3:00 FINISH: 12:00 M136370

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	17.3400 ft (2.89 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X01.500	17	17	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bar	34.625inches ± 0.010	34.635 34.615		34.625
2	Bar	33.650inches ± 0.010	33.660 33.640		33.650
3	Bar	16.639inches ± 0.010	16.649 16.629		16.639
4	Bar	0.488inches ± 0.010	0.498 0.478		.487
5	Bar	0.962inches ± 0.005	0.967 0.957		.963
6	Bar	0.464inches ± 0.010	0.474 0.454		.462
7	Bar	0.504inches ± 0.010	0.514 0.494		.502
8	Bar	0.344inches + 0.006 - 0.001	0.350 0.343	Diameter	.344
9	Bar	0.660inches + 0.008 - 0.001	0.668 0.659	Diameter	.662
10	Bar	100.000Degrees ± 0.500	100.500 99.500		100°
11	Bar	0.512inches ± 0.005	0.517 0.507		.508
12	Bar	0.060inches ± 0.010	0.070 0.050		.06
13	Bar	45.000Degrees ± 0.500	45.500 44.500		45°
14	Bar	4.750inches ± 0.010	4.760 4.740		4.752
15	Bar	12.531inches ± 0.010	12.541 12.521		12.531
16	Bar	16.627inches ± 0.010	16.637 16.617		16.627
17	Bar	21.844inches ± 0.010	21.854 21.834		21.844
18	Bar	29.625inches ± 0.010	29.635 29.615		29.625
19	Bar	0.250inches ± 0.010	0.260 0.240		.250
20	Bar	1.000inches ± 0.010	1.010 0.990		.997
21	Bar	0.125inches ± 0.010	0.135 0.115	Radius	.125
22	Bar	0.987inches ± 0.010	0.997 0.977		.985
23	Bar	0.500inches ± 0.010	0.510 0.490		.500